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011031

D5491-042
Job Sheet 193672



Part No: D5491-042

Job Qty: 5 pcs

Part Name: Step Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/18/19

Job Tracking No:

Created By: Linda Lacelle

Due Date: 7/18/19

Description:

Type: Stock

Note: D5491 REV.B IPP REV:A 18.04.04 NEW ISSUE DD VERF:JFS IPP REV:B 18/08/03 AS PER DWG REV.B
JFS VERF BY:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	5 pcs	7/18/19		0.00	41.67	Small Fab - 1		<i>Smb</i> <i>19/8/28</i>
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	5 pcs	7/18/19		0.00	0.00	QC 5 - 10		<i>DAS</i> <i>40</i> <i>AUG 29 2019</i> <i>19-8-28</i>
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
130	Spray Paint - 2 - B4B	5 pcs	7/18/19		0.00	2.50	Spray Paint - 1 - B4B		<i>19-8-28</i>
							Spray Paint - 2 - B4B		
							Spray Paint - 3 - B4B		
							Spray Paint - 4 - B4B		
140	QC 14	5 pcs	7/18/19		0.00	0.00	QC 14 - 15		
							QC 14 - 2		

PRIORITY

						QC 14 - 34	
						QC 14 - 41	
						QC 14 - 51	
						QC 14 - 58	
						QC 14 - 59	8EB19-08.30
						QC 14 - 9	
						QC 14 - 68	
						QC 14 - 40	
						QC 14 - 19	
150	Handfinish - 3-1- WingWalk- B4B	5 pcs	7/18/19	0.00	2.50	Handfinish - 3 - 1 - B4B	
						Handfinish - 3 - 2 - B4B	8EB19-08.30
						Handfinish - 3 - 3 - B4B	
						Handfinish - 3 - 4 - B4B	
						Handfinish - 3 - 5 - B4B	
160	QC 3	5 pcs	7/18/19	0.00	0.00	QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	ALLG 3 0 2019
						QC 3 - 19	
170	Packaging 3-1 - Stock - B4B	5 pcs	7/18/19	0.00	0.00	Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	

DAS
40

9-89

DAS
28
9-89

				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180	QC 21 - SA	5	7/18/19	0.00	0.00
		pcs			
				QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

DAB
 21 SEP 03 2019
 9-89

Fg dock

Part Op 110 - (Small Fab) 1- ASSEMBLE FIXTURE DT10384 WITH BLOC "A", "B" AND "C" TO MANUFACTURE D5491-041. 2-
 Descriptions: ASSEMBLE D5273-043 FITTINGS TO D5491-1 STEP WITH PROSEAL AS PER DWG A/R
 PROSEAL: _____ 3- INSERT ALL PARTS TOGETHER IN FIXTURE DT10384 AND TRANSFER DRILL
 HOLES USING DT10186 FOR D5499-1 AND DT 10185 FOR D5499-1 AS PER DWG AND NOTES 8,9. 4-
 DISASSEMBLE AND DEBURR. 5- a) USE DT10170 DRILL JIG TO DRILL NUT PLATE HOLES IN D5627-1 TUBE AS
 PER DWG. b) DEBURR c) TOUCH UP HOLES WITH ALODINE ONLY d) INSTALL NUTPLATES IN TUBES 6- TOUCH
 UP HOLES WITH ALODINE ONLY ON D5627 AND D5273-041 FITTINGS. 7- USE DT10384 TO RE-ASSEMBLE REST
 OF THE PARTS TOGETHER USING PROSEAL AS PER DWG A/R PROSEAL: _____ CURE TIME
 24h: _____
 120 - (QC5- Inspect part completeness to step on W/O)
 130 - (Spray Paint / NDT Room) Prime and paint as per dwg. ***MASK SLOTS AS PER NOTE 10***
 140 - (QC14- Inspect Spray Paint) Primer 5200297 Paint 5204428
 150 - (Wing Walk as per dwg QSI005 4.4 Batch 546108) 1- MASK SCREWS AS PER DWG AND APPLY WING WALK
 AS PER DWG. 2- INSTALL PLACARD AS PER DWG. (NOTE11)
 160 - (QC3- Inspect Part Finish)
 170 - (Identify as per dwg & Stock Location: _____)
 180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
CR3212-4-05	Cherry Rivet	30 Ea (6 ea)	110-Small Fab - 1	5105480
CR3242-4-4	Rivet	40 Ea (8 ea)	110-Small Fab - 1	104327
D5273-043	End Fitting Assembly	5 pcs (1 ea)	110-Small Fab - 1	5104457
D5291-041	Radius Block Assembly	15 pcs (3 ea)	110-Small Fab - 1	5151047
D5491-1	Step Extrusion	5 pcs (1 ea)	110-Small Fab - 1	5108130
D5499-2	Aft Bracket Mount	5 pcs (1 ea)	110-Small Fab - 1	5104946
D5625-1	Receptacle	20 pcs (4 ea)	110-Small Fab - 1	5101951
D5627-1	Tube	5 pcs (1 ea)	110-Small Fab - 1	5104214
D5629-041	End Cap Assembly	5 pcs (1 ea)	110-Small Fab - 1	5102753
MS21042L3	Nut	10 Ea (2 ea)	110-Small Fab - 1	5104283
MS24694-S50	Screw	40 Ea (8 ea)	110-Small Fab - 1	5101020
MS24694-S98	Screw	15 Ea (3 ea)	110-Small Fab - 1	5102378
MS27039-1-10	Screw	5 Ea (1 ea)	110-Small Fab - 1	5157316
MS27039-1-30	Screw	10 Ea (2 ea)	110-Small Fab - 1	5106245
NAS1149D0332J	Washer	10 Ea (2 ea)	110-Small Fab - 1	5178838
NAS1149D0363J	Washer	20 Ea (4 ea)	110-Small Fab - 1	5201031
D2137	Decal(No Step)	5 pcs (1 ea)	150-Handfinish - 3-1- WingWalk-B4B	5160996

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	CR3212-4-05	30	139	0
	CR3242-4-4	40	144	0
	D5273-043	5	18	0
	D5291-041	15	87	0
	D5491-1	5	10	0
	D5499-2	5	11	0
	D5625-1	20	100	0
	D5627-1	5	12	0
	D5629-041	5	15	0
	MS21042L3	10	1,578	0
	MS24694-S50	40	363	0
	MS24694-S98	15	171	0
	MS27039-1-10	5	267	0
	MS27039-1-30	10	32	0
	NAS1149D0332J	10	2,313	0
150-Handfinish - 3-1- WingWalk-B4B	NAS1149D0363J	20	1,139	0
	D2137	5	60	0

Part Specifications

Specifications could not be found.